

Work Order ID 67827-2

Thursday, March 31, 2011 1:19:26 PM



Page 1

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011

Start Qty: 100.00

*Spent 45*



Cust Item ID:

Required Date: 4/15/2011

Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

*CL*

Date: 11/03/30

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100



Bandsaw

Jcaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut D2423 dimension to 0.82"

Batch:

*cut @ metec*

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine per folio FA927

FOLIO REV

DWG REV

Check for crack while loading into the machine.

2- deburr

*issue P/O to metec*

*Machine as per drawing D2230 REV. G*

*P/O: 13764*

*CL 11/03/31*

*CL 11/03/31 100*

# Work Order ID 67827

Thursday, March 31, 2011 1:19:26 PM



Page 2

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC *need*  
Quality Control

QC *need* Inspect parts off machine F-A/F-A/B

0.00

Memo

0.00

*need + inspect for transit damage  
attached c.g.c. 40 W10*

130



QC  
Quality Control

QC Inspect parts - second check

0.00

Memo

0.00

*Sulambo*

*counted  
245*

*11/4/20 (75)*

150



Hand finish  
Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

*45 11-4-27*

# Work Order ID 67827

Thursday, March 31, 2011 1:19:26 PM



Page 3

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Item Name: Lug

Stop



Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

45 6 28 11/63/05

170

White Gloss(Ref 4.3.5.1) per QSI005 4 3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

OVEN TEMPERATURE

FINISH TIME

2:10 300  
2:40

45 28 11-5-3

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

45 6 28 11/05/07

# Work Order ID 67827

Thursday, March 31, 2011 1:19:26 PM



Page 4

Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Identify as per dwg & Stock Location 476

0.00



Packaging

Memo

0.00

Packaging

JB

(45)

11/05/04

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/4

11-05-4

(45)

# Picklist Print

Thursday, March 31, 2011 1:19:22 PM

Page 1

Work Order ID: 67827

Parent Item: D2230-3

Parent Item Name: Lug



Start Date: 3/31/2011

Required Date: 4/15/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP D00005.18: Added inspection level 8, and removed P/O for powder  
cont: EC IPP REV :E NEW FOLIO # 10-05-  
25 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	384.5000	0.0683	7.189474			



Lug Extrusion



CH 11/03/83

Location

Loc Qty

Loc Code

MAT006

384.5

43722

161.5

45800

1

63005

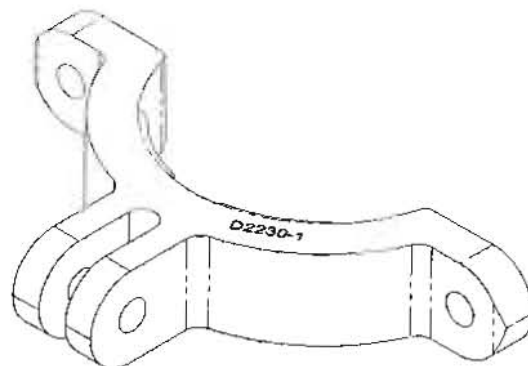
222

D2230-3 P

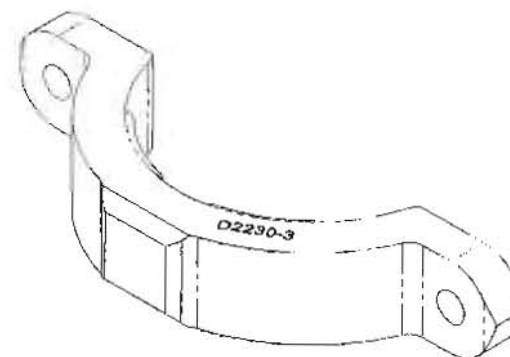
X100

*Ref 4/20 (45)*





D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED  
*Chakras*

CD 11/03/31

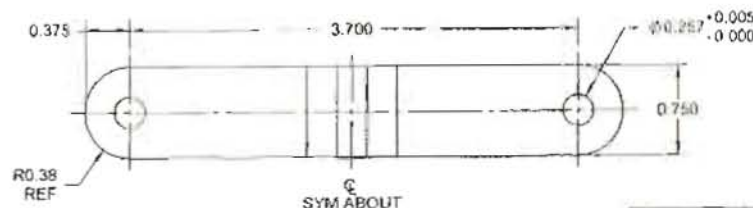
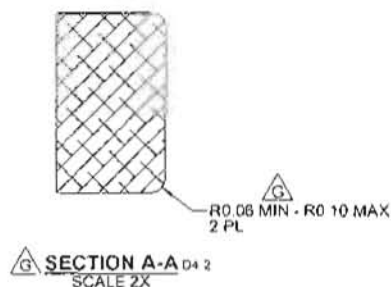
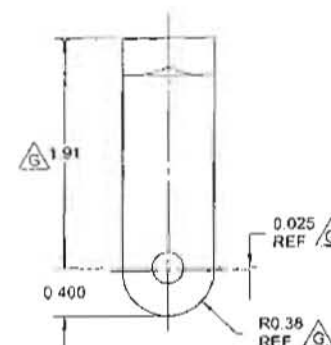
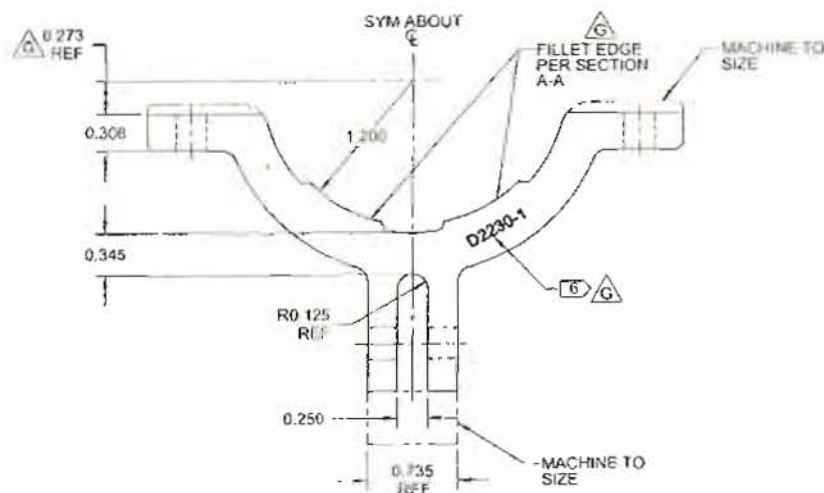
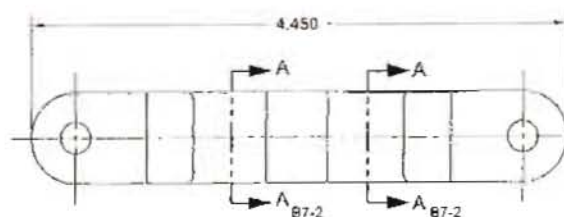
WID: 67827

A

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART Q91-005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART Q91-005 4.3
- 3) TOLERANCES: PER DART Q91-018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.305 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.18 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHASING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	REDESIGN: R1 200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO	REV. G
MFG. APPR.	<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small>Copyright © 1994 by DART Aerospace Ltd. All rights reserved. No part of this drawing may be reproduced or transmitted in any form or by any means electronic or mechanical, including photocopying, recording, or by any information storage and retrieval system, without permission in writing from DART Aerospace Ltd.</small>	



**D2230-1 MOUNTING LUG**

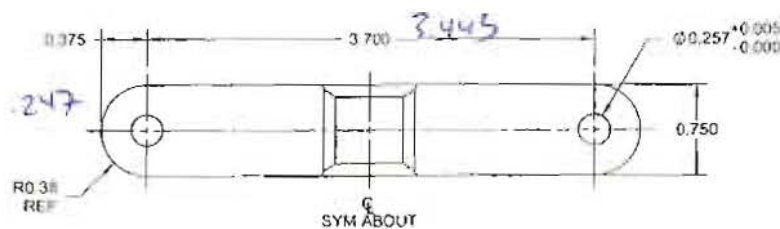
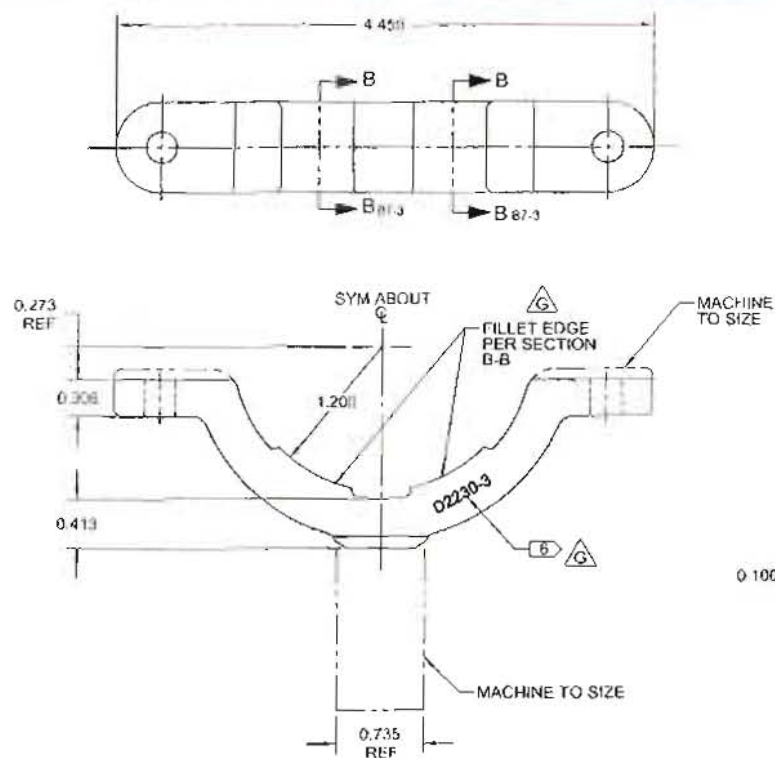
**RELEASED**  
09/06/75

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY ONTARIO CANADA	
CHECKED		DRAWING NO	REV. G
MFG APPR		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	<small>PROPERTY OF DART AEROSPACE LTD This drawing is the property of Dart Aerospace Ltd. and is not to be reproduced or used in any way without the written consent of Dart Aerospace Ltd.</small>	

W/O. 47827

SECTION B-B  
SCALE 2X

R0.06 MIN - R0.10 MAX  
2 PL



D2230-3 MOUNTING LUG

RELEASED  
09/06/2010

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	ALS	HAMILTON, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV G
MFG APPR		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	HTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD	

W10: 7827





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO13764

Purchase Order Date 3/31/2011

PO Print Date 4/6/2011

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, QC K0B 1R0  
CA

Contact Name

Vendor Phone 613 678 3957

Vendor Fax 613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

*REMOVED*

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-1P	LUG	4/22/2011 Yes	100.00 Each	Dart Truck	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67826				
2	D2230-3P	LUG	4/22/2011 Yes	100.00 Each	Dart Truck	\$13.6000	\$1,360.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67827				
3	D3235-1P	lug	4/22/2011 Yes	100.00 Each	Dart Truck	\$15.0500	\$1,505.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B67831				

PO Total: \$4,760.00

*CL*

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 2

Change Date: 4/6/2011



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: 17915  
Date: Apr 19, 2011  
Page: 1

<b>Sold to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13764	<b>Sold By:</b>
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		100
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	45	
D3235-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	15	

The delivered goods must be inspected upon receipt to confirm compliance  
Should there be discrepancies please notify METEC within 30 days of delivery  
The goods are otherwise deemed accepted.

Received by \_\_\_\_\_

Thank you for your order!

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

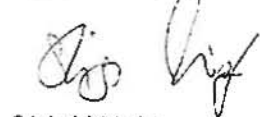
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
45	D2230-3	Mounting Lug	13764
15	D3235-1	Mounting Lug	13764

MATERIAL supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Shigi Walz

Vankleek Hill, April 19, 2011